

Work Order ID 59244

Friday, May 28, 2010 9:52:02 AM

Page 1

Item ID: D3698-1

Accept



Setup Start



Revision ID:

Item Name: Support Angle

Stop



Start Date: 5/27/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan:



Date: 05-28

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3698	Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

KB 10-6-2

FLOW CNC Waterjet

6061 . 030

1-Cut as per Dwg D3698 □ Dwg Rev: C □ Prog Rev: C

****grain direction along 1.378" ****
necessary

□2- Deburr if

EF 10/06/03 (7)

(7)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

KB 10-6-2

Quality Control

120

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

S 10/06/03

Quality Control

(7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130

Operation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Brake NC

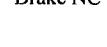


NC BRAKE

0.00



Brake NC



Memo

0.00



1-Bend 105 deg. angle as per Dwg D3698 2-form curve as per dwg D3698 and verify using template DT9001

Sp 10/6/07

140



QC5- Inspect part completeness to step on W/O

0.00

S.066104

QC

Quality Control

0.00



150



Chemical Conversion Coat per QSI005 4.1

0.00

7m-k 10/06/07

HandFinish

Hand Finishing

0.00



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Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

QC: _____

Date: _____

Tooling: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start



Stop

Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC3- Inspect Part Finish

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

7

Reject
Qty

0

Reject
Number

Insp.
Stamp

170



Packaging

Packaging

Identify as per dwg & Stock Location: *24/A*

0.00

0.00

Pete/8/0

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

10/06/08
MF
10-6-8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Friday, May 28, 2010 9:52:07 AM

Page 1

Work Order ID: 59244



Parent Item: D3698-1



Parent Item Name: Support Angle

Start Date: 5/27/2010

Required Date: 6/4/2010

Comments: IPP Rev:A 08-04-25 new issue DD verified by:EC
IPP Rev:B 08-07-14 revB as per dwg DD verified by:ec
IPP rev:C 08-10-07 revC as per dwg DD verified by:EC

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ M6061T6S.032	Replacement 6061-T6 Sheet 0.032"	Mfg/ Purchased	Bin No	Primary	Last	Route 100	Unit of sf	Qty on 73.0000	Qty per Kit 0.4476	Total 2.355789	Qty 3.3	Date 1810-6-2	Status

Location	Loc Qty	Loc Code
MAT21	73	
110063	3	
112763	56	112763
16954	8	
18375	6	

7

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DART AEROSPACE LTD	Work Order:	59204
Description: Support Angle	Part Number:	D3698-1
Inspection Dwg: D3698	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>HB</u>	Audited by:	<u>S</u>	Prototype Approval:	N/A
Date:	10-6-2	Date:	10/6/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DD	
B	09.05.11	Dimensions updated per Dwg Rev C	KJ	

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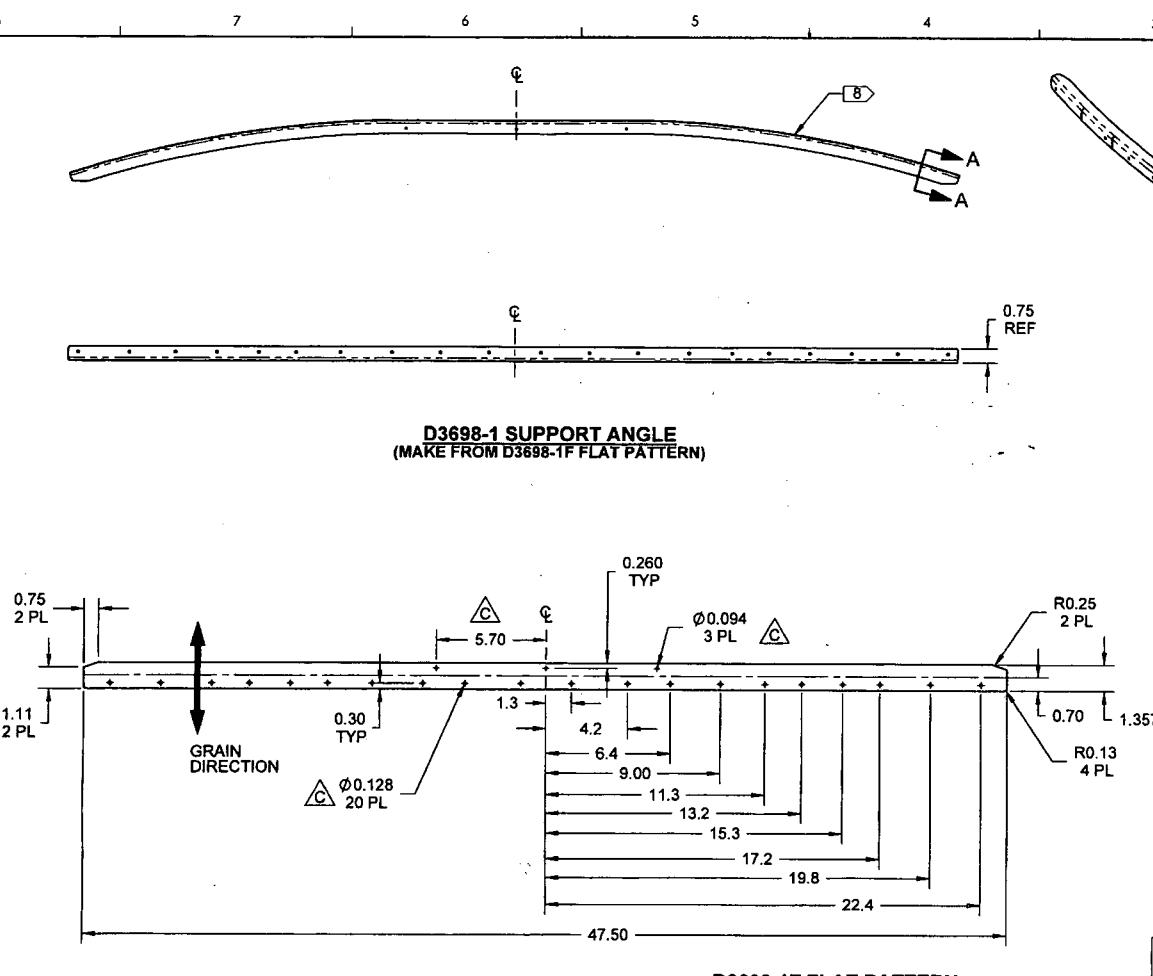
SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 59299

PLT-A-5-28



NOTES:
1) MATERIAL: 6061-T6 (QQ-A-250/11) SHEET 0.032 THICK
REF. DART SPEC. M6061T6S.032

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.20 lbs
- 8) FORM AS PER TEMPLATE DT9001

C	ZONE B5 Ø0.094 HOLE QTY WAS 29 PL. ZONE B6 ADDED "Ø0.128, 20 PL". ZONE B6 5.70 DIMENSION WAS REF.			AJS	08.09.08
B	REMOVE POWDER COAT. ZONE A.8			RF	08.06.02
A	NEW ISSUE			RF	08.05.12
REV.	DESCRIPTION BY DATE				
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	RF	DRAWING NO. REV. C D3698 SHEET 1 OF 1			
CHECKED	AS	MFG. APPR. <i>[Signature]</i> APPROVED <i>[Signature]</i> DE APPR. <i>[Signature]</i>			
DATE	08.09.08	TITLE SCALE SUPPORT ANGLE NTS			

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